

5/46

DART AEROSPACE LTD		Work Order:	24674
Description: Guide		Part Number:	D3112-1
Drawing: D3112 Rev. <sup>RF 04.11.29</sup> AT B		Qty:	10

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	<i>[Signature]</i>	05.10.26	10
2	METAL /CNC-CELL	Cut blanks: 0.625" x 1.500 bar x 2.625" long. Material: 6061-T6/T6511/T651 ( QQ-A-225/8 OR QQ-A-200/8) Bar ref DART spec M6061T6B Batch <u>M17037</u>	BG	05.11.06	10
3	HAAS	Machine as per Folio FA233 <del>Note: Engrave / scribe DART P/N on part as per dwg.</del>	BG	05.11.07	10
4	QC	Inspect Level 2	BG	05.11.07	10
5	QC	Inspect Level 8	SN	05.11.07	10
6	METAL/CNC-CELL	Deburr break all unmarked sharp edges .005 to 0.010	BG	05.11.07	10
7	QC	Inspect Level 5	BG	05.11.07	10
8	FINISHING	Chemical conversion coat as per QSI 005 4.1	<i>[Signature]</i>	05.11.15	10
9 A	FINISHING	Powder coat grey sandtex ( 4.3.5.6 ) per QSI 005 4.3.	<i>[Signature]</i>	05.11.15	10
9 B	QC3	Inspect work to step 9A	C2	05.11.16	10
10	STORES	Identify and stock <sup>LUC 84</sup> with P/N & B/N using fine point permanent ink marker	<i>[Signature]</i>	05.11.16	10
11	EXPEDITING	Close W/O Inspect level 21 Cost/part <u>12.22</u> <sup>sur 05/11/21</sup>	<i>[Signature]</i>	05.11.21	10

Rev	Date	Change	Revised By	Approved
A	02.05.22	New Issue	NG	<i>[Signature]</i> 02.05.22

RELEASED

02/05/22

RF  
02.12.10  
RF  
04.11.29

413

C2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/11/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

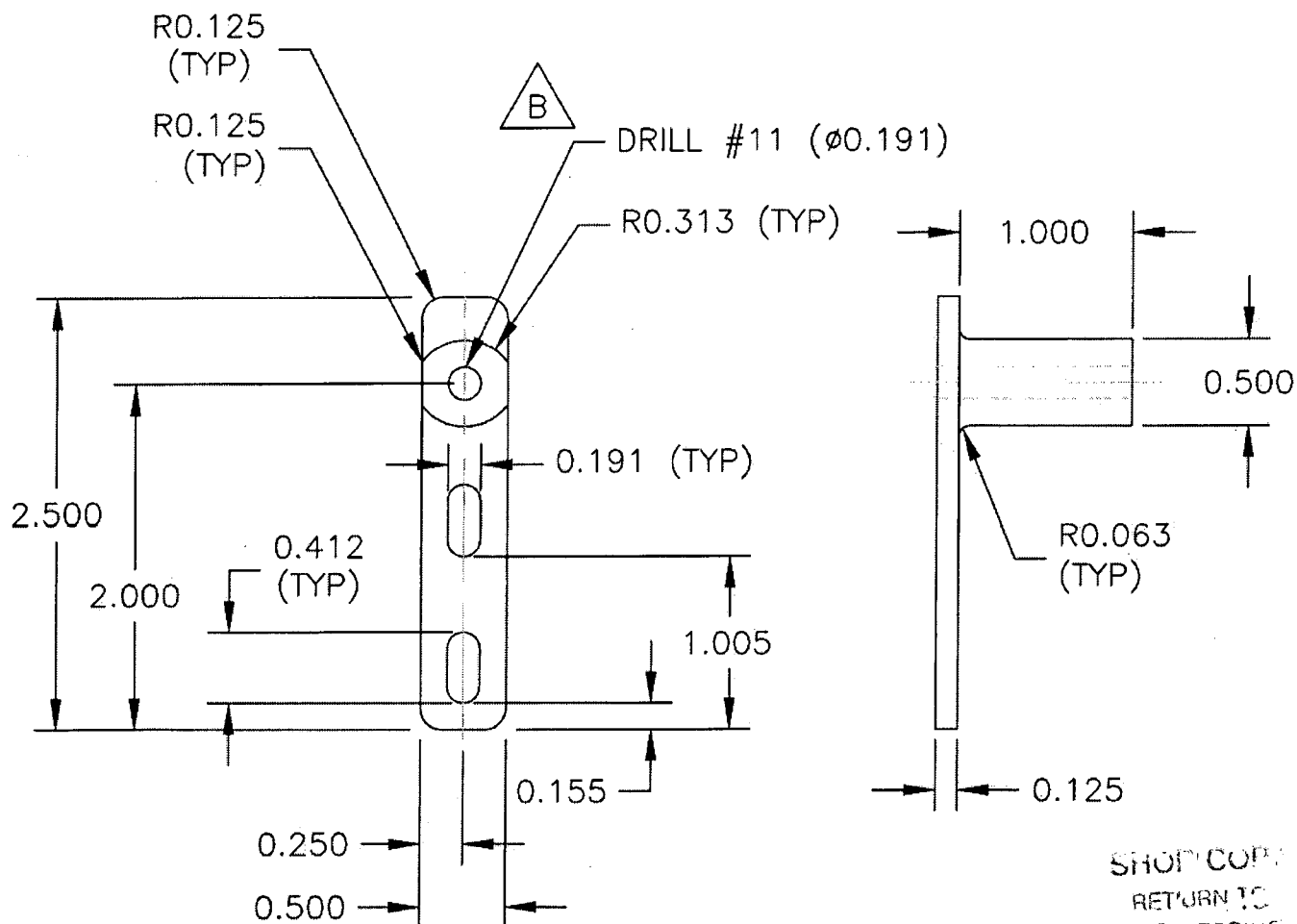
NOTE: Date & initial all entries





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3112	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE GUIDE	SCALE 1:1
A	02.04.12	NEW ISSUE	
B	04.10.18	ADD PART MARKING; $\phi 0.191$ WAS $\phi 0.185$	

RELEASED  
04.11.23



### D3112-1 GUIDE

#### NOTES:

- 1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF. DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-17
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO  
WITHOUT NOTICE

WORK ORDER

NO. 24674

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## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 25, 2005  
04:04 pm

Work Order No : 0024674  
Project Name : D3112-1  
Project For : WK546  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3112-1  
Description : Guide  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 10-25-05  
Est Finish Date : 11-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
12:44 pm

Work Order No : 0024674  
Project Name : D3112-1  
Project For : WK546  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3112-1  
Description : Guide  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 10-25-05  
Est Finish Date : 11-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

M/S 0/13  
u  
11.15

Date: Monday, 14/11/2005 3:51:28 PM  
 User: Alba Panzuto

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : GUIDE
<b>Job Number</b> : 24674	
<b>Estimate Number</b> : 10367	
<b>P.O. Number</b> :	<b>Part Number</b> : D31121
<b>This Issue</b> : 14/11/2005 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3112 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 24335	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/12/2005 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est. A 02.05.22    New Issue NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"
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2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blanks: 0.625" x 1.500 bar x 2.625" long.

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA233

Note: Engrave / scribe DART P/N on part as per dwg.

Deburr break all unmarked sharp edges .005 to 0.010

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------

**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Date: Monday, 14/11/2005 3:51:28 PM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 24674

Part Number: D31121

Job Number:



Seq. #:	Machine Or Operation:	Description :
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7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

